Work Order Tuesday, Septembe											Page 1
	3578-041			Accept				·s	etup Star	t	
Revision ID: Item Name: De	oubler								Stop		
Start Date: 9/ Required Date: 9/ Reference:		Start Qty: 30.00 Req'd Qty: 30.00			Cust Item II Customer:	D:					
	Process Plan: QC:	V	Date: 10-408	Tooling: _ SPC (Y/N):		te:		R	tun Star Stop		848 184 148 1886 8118 188 188 1881
Sequence ID/ Work Center ID		peration escription		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisio	on Nbr									
D3578	Rev A										
Waterjet FLOW CNC Waterjet		LOW WATER JET Memo 1-Cut as p Rev:	er Dwg D3578 (Run prog. D3 ♣ □2-Deburr if necessary	0.00 0.00 578-1) □Dwg Rev:	□Prog			<u></u>	x 92 15		—
110 QC Quality Control	Q	C2- Inspect parts off Memo	machine FAI/FAIB	0.00				H\$(<i>۵ حو</i> د روح		<u> </u>
120 QC	Q	C8- Inspect parts - se	econd check	0.00	orlia			countre (432)	<i>p</i>		

Quality Control

	-							
W/O:			WO	RK ORDER CHANGI	ES			*
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	Jory:	NCR: Yes	lo DQA:	Date: _	
	Re	solution:	Disposition	1:	_ QA: N/C Clo	sed:	Date: _	
NCR:		1	WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
							Į	
					,			

Work Order ID 61846

Tuesday, September 07, 2010 3:38:10 PM



Page 2

Item ID:

D3578-041

Accept



Setup Start



Revision ID:

Doubler Item Name:

Required Date: 9/13/2010

9/7/2010

Start Qty: 30.00

Req'd Qty: 30.00

Cust Item ID: Customer:



Reference:

Start Date:

Approvals:

Process Plan: _____ Date: Tooling:

Date:

Tool ID

Run

Start

Stop

Stop



Date: SPC (Y/N):

Tool # Plan

Code

Accept Oty

Reject Reject Qty Number

Insp. Stamp

Sequence ID/ **Work Center ID**

130

Small Fab

Small Fab

Operation Description

Small Fab

Set Up/ **Run Hours**

0.00

0.00

1-Open rivet holes to 0.098" and C'sink as per dwg D3578

Date:

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

Memo

Memo

W/O:			W	ORK ORDER CH	ANGES					<u> </u>
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	egory:	NC	R: Yes	No DQ	4 :	Date:	
Resolution:			Disposition	on:	QA	: N/C Cld	osed:		Date: _	<u>.</u>
NCR:			WORK ORD	ER NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
DATE	SILF	Section A	Initial Chief Eng	Action Descrip Chief Eng	otion ————————————————————————————————————	Sign & Date	Secti	on C	Chief Eng	QC Inspector
					·					
								•		

Work Order ID 61846

Page 3

Tuesday, September 07, 2010 3:38:10 PM

Required Date: 9/13/2010

Item ID:

D3578-041

Accept



Setup Start



Revision ID:

Start Date:

Item Name:

Doubler

9/7/2010

Start Qty: 30.00 Req'd Qty: 30.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Tooling:

Date:

Start Run



QC: ____

Date:

SPC (Y/N):

Date:

Stop

Stop

Sequence ID/ Work Center ID

QC

Operation Description

QC3- Inspect Part Finish

Set Up/ Tool ID

Run Hours

Tool # Plan

Code Qty

Reject Accept Qty

Reject Number Stamp

Insp.

Quality Control

Memo

0.00

0.00

170

Small Fab Small Fab

Small Fab

Memo

Memo

0.00

1-Assemble as per dwg D3578

0.00

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Diolog/21

	12								
W/O:			W	ORK ORDER CHANG	SES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A :	Date: _	
Resolution:		esolution:	Dispositi	on:	QA: N/C (closed:		Date: _	
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			tion B	Verific	cation	Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector
				-					
								<u>}</u>	
				•					

Work Order ID 61846

Tuesday, September 07, 2010 3:38:10 PM



Page 4

Item ID:

D3578-041

Accept

Setup Start

Stop



Revision ID:

Doubler Item Name:

Start Date:

Required Date: 9/13/2010

9/7/2010

Start Oty: 30.00

Reg'd Oty: 30.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date: Tooling:

Memo

Date:

SPC (Y/N):

Date:

Tool ID

Date:

Start

Stop

Sequence ID/

Work Center ID

190

Packaging

Packaging

Operation Description

OC:

Identify as per dwg & Stock Location:

0.00

Set Up/

Run Hours

Tool # Plan Code

Accept Qty **Qty**

Run

Reject Reject

Insp. Number Stamp

0.00

200

OC

Quality Control

OC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/22 75 MF 10-9-21

W/O:			WC	RK ORDER CHANGI	ES			-
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							Prod Mgr	
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	Resolution:							
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approvai	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
	-							
								-
٠								

Picklist Print

Tuesday, September 07, 2010 3:38:14 PM

Work Order ID: 61846

Parent Item:

D3578-041

Parent Item Name: Doubler



Start Date: 9/7/2010

Required Date: 9/13/2010

Page 1

Start Qty: 30.00

Required Qty: 30.00

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IDD: A D 07 04 11 D Nove in the DECD

	Replacement tem ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date St Issued	tatus
3569 NI YOU G	whilev	Manufactured	No			110	Each	22.0000	1	30			
illi illi illi illi illi illi illi ill	harnes	s w			Hurs	ul				<u> </u>			
<i>@</i> 6)			Location		Loc	Q ty	Loc Code					
				ST245A			22		_		-		
0204264 D2-2				;	32084		22		_		-		
S20426AD3-3 		Purchased	No			110	Each	5,021.000		60			
vet		}								£50	0/09	/21_	
				Location		Loc	<u>Oty</u>	Loc Code					
				ST316			5021		_		-		
					19099 7681		4774 247		_	68	-		
5061T6S.080		Purchased	No		7001	170	sf	0.3512	0.007	0.221053	-)		
		II.	1.0			170	31	0.5512		0.221033			
61-T6 .080 Sheet	IB IIBIII BAIBI XBIII BBII IBI	i									310-9	-14	
- 10.000 0.000				Location		Loc	<u>Oty</u>	Loc Code				5	
				MAT21		0.	3512					(~)	
					113438	0.	3512		_	113438)		
S21075L3		Purchased	No			170	Each	82.0000	1	30		r	
										F/S	20 /0	19/21	
utplate										7		//~	
				Location		Loc	<u>Oty</u>	Loc Code			-		
				ST303			82		_		-		
					113734		1		_	20	-		
					114760		81		_	3,2	-		

	•									
W/O:			W	ORK ORDER CHANG	SES					
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	egory:	NCF	R: Yes	No DQ	A:	_ Date: _	
	Res	solution:	Disposition	on:	QA:	N/C CIG	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)	,		
DATE	STEP	Description of NC			tion B		Verific	cation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		on C	Chief Eng	QC Inspector

DART AEROSPACE LTD	Work Order:	41844
Description: Doubler	Part Number:	D3578-1
Inspection Dwg: D3578 Rev: A		Page 1 of 1

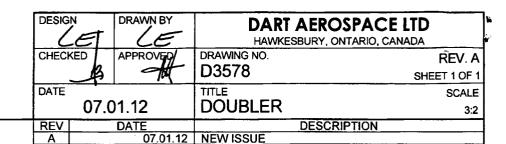
Inspection Dwg	: D3578 R e	v: A				F	age 1 of 1		
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	rin.	X First A	_						
	L		Title [FIO	totype				
Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Co	omments		
Dimension		Dimension							
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Ø0.203	+0.005/-0.001	. کرع	*		V				
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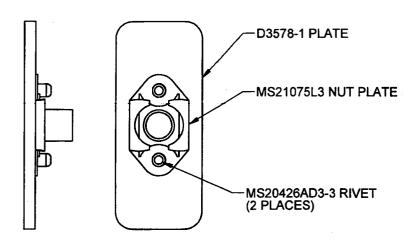
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Measured by:	B	Audited by			Prototype App	-	N/A		
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Revised by Ann									

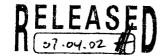
Rev	Date	Change		Revised by	Approved
Α	07.11.23	New Issue	P/O D3578-041	KJ/EC/DD	Z

W/O:			W	ORK ORDER CHANGI	ES									
DATE	STEP	PRO	OCEDURE CHA	NGE	В	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Dort No.		DAD #.	Fault Cata		NCD.	/aa N			Data					
Part NO		PAR #: esolution:												
NCR:			WORK ORD	ER NON-CONFORMA	NCE (N	ICR)								
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description		gn &		cation	Approval	Approval QC Inspector				
		Section A	Chief Eng	Chief Eng		ate	Secti	on C	Chief Eng	QC Inspector				









D3578-041 PARTS LIST:

QTY	P/N	DESCRIPTION				
X	D3578-041	DOUBLER				
1	D3578-1	PLATE				
1	MS21075L3	NUT PLATE				
2	MS20426AD3-3	RIVET				

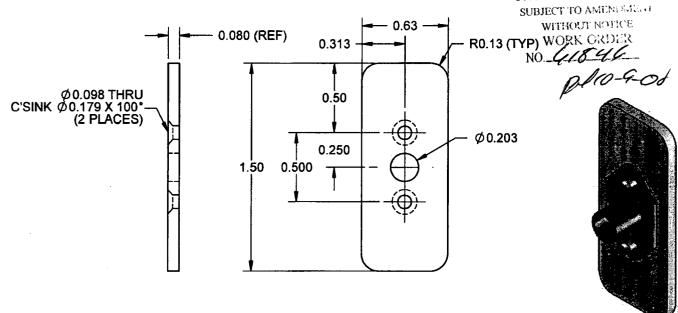
D3578-041 DOUBLER

D3578-041 NOTES: 1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER SHOP COPY

RETURN TO

ENGINEER!: 13

UNCONTROLLED COMY



D3578-1 PLATE

D3578-1 NOTES

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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Dart Ae	rospace	e Ltd							
W/O:			WO	RK ORDER CHANGE	ES				
DATE STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQA	\:	Date: _	
Resolution:		Disposition: (QA: N/C Clo	QA: N/C Closed: Date:				
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)				
DATE	STEP	Description of NC	Corrective Action Section B			Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
								·	